

Work Order ID 79191

Monday, January 23, 2012 11:40:16 AM

79191

Page 1

Item ID: D205-778-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Comfort Seat, LH/RH

Stop ***NS2***

Start Date: 1/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/24/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *12-01-23* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3800	B
DSI 9508	A
IIN D205-778	Rev B

100

100

DC

Document Control

DOCUMENT CONTROL *sf*

Memo

Photocopy bluefile & type labels per PPP D205-778-011 CHG 003

0.00

0.00

S 12/01/23

12-1-23
MLJ
(2)

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

12/1/23
sf

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79191

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Page 2

Item ID: D205-778-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Comfort Seat, LH/RH

Start Date: 1/23/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/24/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-778-101

Location:

PPP Rev: D

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/1/23
R12-01-23
E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 23, 2012 11:40:15 AM

Page 1

Work Order ID: 79191

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 1/23/2012

Required Date: 1/24/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
10.03-24 verified by:EC
IPP Rev:B as per DSI 9508 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	756.0000	16	32			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST337A		756							
				5519		756							
BSP-42 Rivet		Purchased	No			110	Each	56.0000	8	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST284		56							
				114598		56							
D3752-1 Seat Frame		Manufactured	No			110	Each	4.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252A		4							
				76281		1							
				77116		3							
D3755-041 Seat Cushion		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST252A		3							
				73157		3							
D3756-041 Cushion		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST258A		3							
				73158		3							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 23, 2012 11:40:16 AM

Page 2

Work Order ID: 79191

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 1/23/2012

Required Date: 1/24/2012

Start Qty: 2.00

Required Qty: 2.00

D3758-041

Clamp

Manufactured No

110 Each 13.0000

2 4

Location

Loc Qty

Loc Code

ST458

13

73159

13

Manufactured No

110 Each 34.0000

2 4

Location

Loc Qty

Loc Code

ST458

34

73160

10

73975

24

Manufactured No

110 f 112.5000

2 4.2105263

Location

Loc Qty

Loc Code

ST064

112.5

56393

52.5

60044

60

Purchased No

110 Each 75.0000

8 16

Location

Loc Qty

Loc Code

ST345

75

119307

75

Purchased No

110 Each 83.0000

8 16

Location

Loc Qty

Loc Code

ST344

83

117395

8

119531

25

120308

50

Purchased No

110 Each 0.0000

8 16

AN960JD10

Washer

NAS1149D0363J

MP20142 12/1/23

Monday, January 23, 2012 11:40:16 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, January 23, 2012 11:40:16 AM

Page 3

Work Order ID: 79191

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 1/23/2012

Required Date: 1/24/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

5,671.0000

8

Nut

12/1/16 238 (2)

Location

Loc Qty

Loc Code

ST300

5671

117441

16

117885

32

118451

5

118927

3

119017

5150

119075

465

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

REFERENCE ONLY

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:


QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIVET KIT	NTS
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